



Date: Monday, 23/02/2009 3:54:41 PM
User: Linda Lapelle

Process Sheet

SP/17

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BEARING ASSEMBLY
Job Number : 46031-1	
Estimate Number : 10716	
P.O. Number :	Part Number : D3121241
This Issue : 23/02/2009 S.O. No. :	Drawing Number : D3121 REV E
Prsht Rev. : NC	Project Number : N/A
First Issue : 1/1 Type : MACHINED PARTS	Drawing Revision : E
Previous Run : 45867	Material :
Written By : 	Due Date : 10/03/2009 Qty: 80 Um: Each
Checked & Approved By : 	
Comment : Est Rev:A 04.02.18 New issue KJ/DS	
Est Rev:B ECN 1060 07-11-12 DD verified by:EC	

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 MDELNR12500 DELRIN ROUND BAR 1.25"



Comment: Qty.: 0.0546 f(s)/Unit Total: 3.2760 f(s)
Material: Ø1.25 Delrin Rod
(M-DELRIN-R1.2500)Identify as D3121-25
Batch: 1110256

ml 09/03/02

2.0 HARDINGE HARDINGE CNC LATHE SMALL



Comment: HARDINGE CNC LATHE SMALL

1-Turn D3121-25 Cap as per Folio FA387

2-Deburr

ml 09/03/02

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ml 09/03/02

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

SP 09/03/03

5.0 D312123 Bearing



Comment: Qty.: 1.0000 Each(s)/Unit Total: 60.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3121-23

Bearing

043550

SP 09/03/03

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARING ASSEMBLY

Part Number: D3121241

Job Number: 46031

Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Press D3121-23 Bearing into D3121-25 Cap as per Dwg D3121

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09/03/03 (67)
02/03/04 (67)
counter

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

235A

9/3/4

SD

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/03/05

Job Completion



09.03.04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

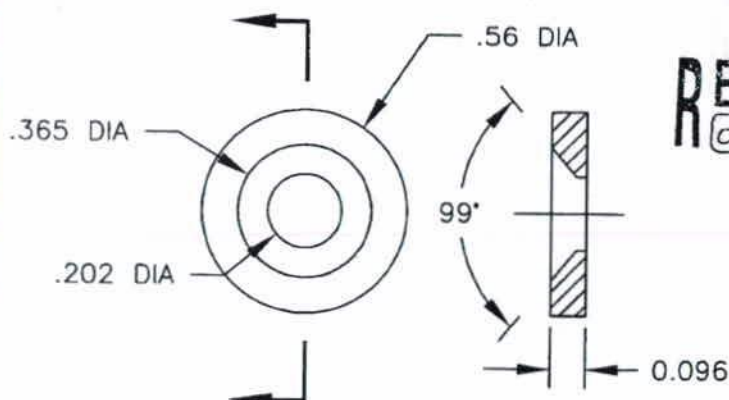
Part No: D3121-241 PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: A Date: 09/03/05
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>46031</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
7/3/04	6-2	Found one (Qty x1) Bearing Damaged. P.C. either installing the tire or manufacture.	<u>Res/12</u>	Bearing is scrap Qty x1 no replace	<u>EB</u> 09/03/04	<u>S</u> 02/03/05	<u>Res/12</u>	<u>S</u> 02/03/04

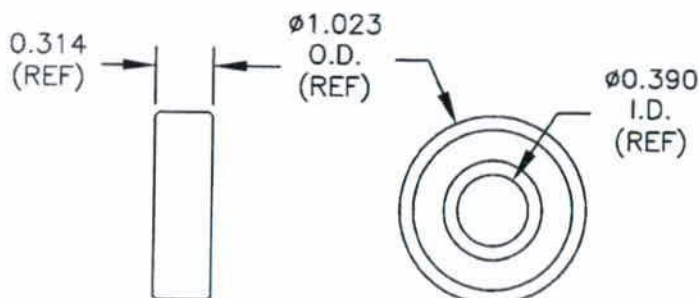
NOTE: Date & initial all entries

DART

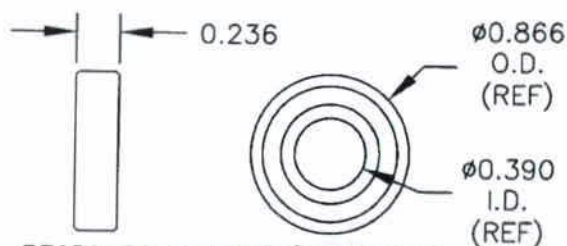
DESIGN #	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3121	REV. E SHEET 10 OF 10
DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:1

**D3121-17 WASHER (SCALE 2:1)**

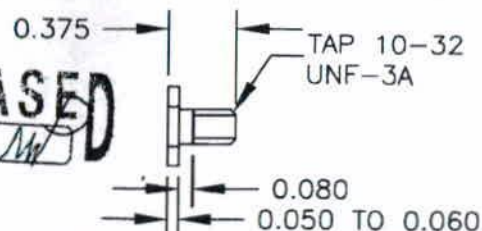
- 1) REPLACES PREMIER P/N B32-23001-17
- 2) MATERIAL: AISI 303 SS ROUND BAR, ANNEALED (REF DART SPEC. M303R)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D3121-19 BEARING (SCALE 1:1)**

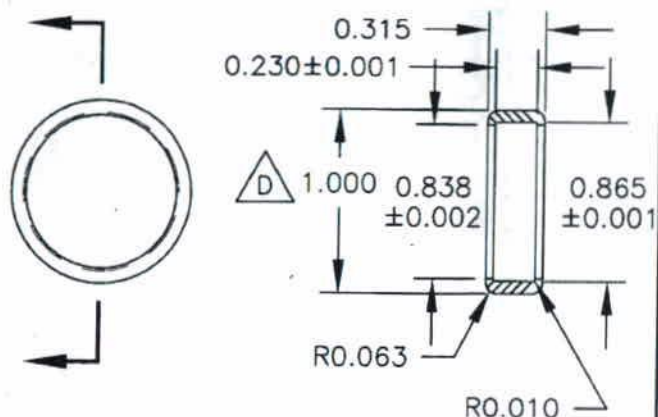
- 1) POSSIBLE SUPPLIER: KING BEARING P/N 6000-2ZJ/EM FAFNIR P/N 9100KDD
- 2) ALL DIMENSIONS ARE IN INCHES

**D3121-23 BEARING (SCALE 1:1)**

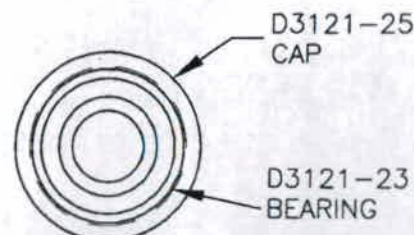
- 1) POSSIBLE SUPPLIER: SKF P/N 61900-22 OR KML P/N 6900-ZZ
- 2) ALL DIMENSIONS ARE IN INCHES

**D3121-21 BOLT (SCALE 1:1)**

- 1) MATERIAL: AISI 303 SS HEX, ANNEALED (REF DART SPEC. M303H0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D3121-25 CAP (SCALE 1:1)**

- 1) MATERIAL: DELRIN ROD, ϕ 1.25 (REF DART SPEC. M-DELRIN-R1.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

**D3121-241 BEARING ASSEMBLY (SCALE 1:1)**

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